



KROMAN ÇELİK SANAYİ A.Ş.

DOCUMENT NO	300/P-08/01
REVISED NO	05
DEPARTMENT	Quality Man.
DATE	20.03.2003

1.AIM

To explain the system used to ensure that billets and rolling products are identified and tracked at all stages of production, when the customer is shipped, and after they arrive at the customer.

2.COVERAGE

This procedure covers the production and marketing activities of melt shops and rolling mills.

3. RESPONSIBILITY

Procedure prepared by PP&QC Manager and confirmed by General Manger.

4.PROCEDURE

4.1 Checking the compliance of the purchased raw materials (scrap, ferroalloy, coal, etc.) with the relevant Technical Specifications for the inspection and test situations, Purchasing, Steel Shop and Quality Manager.

4.2. Countries scraps domestic market, European countries, Russia, U.S.A. and in the Baltic countries. Radiation controls are made at the entrance.

4.3. Input controls of raw materials such as ferro alloys, lime, anthracite are used in our laboratory as well as accredited external laboratories and used as long as they are in accordance with technical specifications.

After all; As Kroman Çelik San. A.Ş. , by developing our technological infrastructure in our sustainable supply chain and the ethical supply chain for high traceability limit, it monitors the production, completion, stacking and the last user in the construction of the building used from our suppliers, by purchasing our main and most important input raw material(Scrap). In general, collecting scraps coming to our supplier cannot be traced backwards because they cannot be tracked effectively.

4.4 Suitable raw materials are started to be produced by charging EAO at the first stage of production.

4.5. Meltshop production is composed of unit productions called "Heat" and covering various activities complementing each other.

4.6. Each heat consists essentially of the same activities, periodically repeating these activities constitute the production process.

4.7. A "heat" is about about 140 tons of EAF, billets are obtained.

4.8. Heats are identified by a number assigned to them, all billets of a pile are treated according to this number.

4.9. The billets obtained from the cast are identical in chemical analysis; But may differ from each other in terms of features such as some physical measurements and tolerances.

4.10. Records of all activities involved in a "Heat" process are kept in SAP with the casting number they belong to and the ERP program.

4.11. The casting number traceability method ERP program is defined in SAP as follows: (8) The first number specifies the number of the EAO number (No: 3 EAF), the last digit of the year found in the second digit,

Example;Heat No:

312-01509

Example; Heat No: When casting numbers are written on the billet, only the last four digits (1509) are used to record all the digits. Different lengths and sections within the same heat number are also identified by the addition of the letters in certain records (Daily Billet Stock Report: 300 / F-10 / 03.A).

312-01509-A



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This heat is the 1509th heat produced from the year beginning in 2012 and specifies that the cast is in two different lengths or cut section billets.

4.12. Numbers may be used for special purpose chalk pen oil paint etc. on the tip of the blank or on any face.

4.13 Stacking of finished billets, shipment to the rolling mill or loading of the customer to be shipped shall be carried out with reference to the casting number to which they belong. The painting of the special quality steel billets produced is made according to the following table (300 / F-08 / 01.B) and sent to the customer.

Steel Grade	Color Code	Steel Grade	Color Code	Steel Grade	Color Code	Steel Grade	Color Code
ST 37	[Color]	SAE 1008	[Color]	SAE 1080	[Color]	16 MnCr 5	[Color]
ST 37-2 (S235JR)	[Color]	SAE 1010	[Color]	SAE 1090	[Color]	31 CrV 3	[Color]
ST 42	[Color]	SAE 1015	[Color]	SAE 4140	[Color]	41 Cr 4	[Color]
ST 44-2 (S275JR)	[Color]	SAE 1018	[Color]	SAE 5135	[Color]	46 Si 7	[Color]
ST 50-2 (E295)	[Color]	SAE 1020	[Color]	SAE 5140	[Color]	31 CrV 3	[Color]
ST 52-U (S355JU)	[Color]	SAE 1025	[Color]	SAE 8620	[Color]	55 Cr 3	[Color]
ST 60-2 (E355)	[Color]	SAE 1030	[Color]	SAE 9260	[Color]	55 Si 7	[Color]
ST 70-2 (E360)	[Color]	SAE 1035	[Color]	SAE 9252	[Color]	60 Si 7	[Color]
ST 80	[Color]	SAE 1040	[Color]			60 SiCr 7	[Color]
Cq 10	[Color]	SAE 1045	[Color]			60 SiMn 5	[Color]
Cq 15	[Color]	SAE 1050	[Color]				
Cq 35	[Color]	SAE 1060	[Color]				
Ck 45	[Color]	SAE 1065	[Color]				
		SAE 1070	[Color]				

BS 4449
ASTM A36
ASTM A615 GR 40
ASTM A615 GR 60
ASTM A572 GR 60
ASTM A706 GR 60

ORJINAL BELGEDİR ÇIKTI OLARAK ALINAN BİLGİLER KONTROLSUZ KOPYADIR

Tablo: Kroman Çelik Billet Color Codes(300/F-08/01.B)



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4.14 Billets physical control for the imported billets and identification of traceability within the delivery process. In addition to the billet numbering system we provide to our production described in 4.7, the exported

billet origin is given as the company code before the above number, the instruction on company codes 300 / T-08 /01.A is explained in detail and how the code issuing system is installed.

4.15 Necessary records in production activities in rolling mills are created using the casting numbers of the billets used as input material. .The product number given to the products obtained during rolling mill production is followed by a number starting with 1 derived from SAP. And in the background, it can be matched with the actual casting number via SAP.

4.16 . All kinds of billets, all kinds of inspection and test reports of rolled products, and quality certificates are created using the heat numbers. Special quality steel wire rods produced by attaching a color label are made according to the following table (300 / F-08 / 01.C) and sent to the customer

						
1006T+	1006C	20MnB4	27MnB4	30MnB4	23MnB4	17MnB3

4.17 A possible complaint to be received from the client is to search the SAP for the ERP program based on the heat number.

4.1 The exported goods sent to port are followed by the order numbers determined for the label and export material attached to the product.